Wo	rk	Or	der	ID	56742
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March 5, 2010 11:23:47 AM



Page 1

Item ID:

D412-742-041

Accept



Setup Start

Stop



Revision ID:

Item Name: Replacement Float Skidtube

Required Date: 17/03/2010

Start Date: 0

05/03/2010

Start Qty: 1.00

Req'd Qty: 1.00

Cust Item ID: Customer:

Reference:

Approvals:

Process Plan:

QC:

Il.

Date 6305 Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop ||||||

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

0.00

0.00

Draw Number Draw Plan Rev. Code Accept Qty Reject Qty Reject Insp. Number Stamp

Draw Nbr

Revision Nbr

Rev H

D3391

100

Document Control

DOCUMENT CONTROL

Memo

If D412-742-041 is a W/O on it's own,

Date:

Photocopy bluefile and create labels per PPP D412-742-041 CHG004

1/2/1/2

Dart Aerospace	Ltd
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W/O:			.W	ORK ORDER CHANGE	ES			_		4 , , ,
DATE	STEP	PRO	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	,									
					,				,	
		>							,	
Part No	:	PAR #:	Fault Cat	egory:	NCF	R: Yes	lo DQ	A:	Date:	
	Resolution:			Disposition: QA: N/C Closed:						
NCR:	-	V	WORK ORE	DER NON-CONFORMA	NCE	(NCR))		10.00	
DATE	STEP	Description of NC	tion of NC Corrective Action			Section B Verificat			Approval	Approval
DAIL	JILF	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section		Chief Eng	QC Inspector
										<u>.</u>
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Work Order ID 56742	W	ork	Ord	er ID	567	42
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March 5, 2010 11:23:47 AM

Required Date: 17/03/2010



Page 2

Item ID:

D412-742-041

Accept

Setup Start



Revision ID:

Item Name:

Replacement Float Skidtube

Start Date:

05/03/2010

Start Qty: 1.00

Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Ap	provals:
4.4	pi v ruis.

Process Plan: _____ Date:

Tooling:

Date: ____

Rev.

Date:_

Start Run



QC: _____ Date: ____

SPC (Y/N):

Set Up/

Run Hours

Draw

Number

Draw Plan

Code

Accept

Reject Reject Oty

Stop

Stop

Insp.

Sequence ID/ **Work Center ID**

110



HandFinish

Hand Finishing

Operation Description

HandFinishing

0.00

Qty

Number Stamp

1-Install tubes together and seal them all the way around using Sikaflex 241/291. Ensure tube ends line-up with saddle holes for proper alignment, using 7/16" "T" Pins.

A/R - Sikaflex-241/-291 - M 115/14 Expiry date:

2-Install wearplates as per Dwg D3391. Ensure that plastic washers are against wearplate, then topped with the SS washer. Seal all bolts with sikaflex exept ones with inserts on inside of tube ,hand tighten only bolts with no sikaflex. A/R□Sikaflex-241/-291□ /////5/(4

3-Remove "T" pins once sikaflex is dry.

Expiry date: □ [[] O T

QC5- Inspect part completeness to step on W/O

4-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser.

WA/ROLPS Procyon M 114596

120



Memo

0.00

0.00

Quality Control

	•									*
W/O:		The state of the s	W	ORK ORDER CHANG	GES					
DATE	STEP	PROCEDURE CHANGE					Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cat	egory:	NCF	R: Yes	No DQ	4:	Date: _	
		solution:								
NCR:		,	WORK ORI	DER NON-CONFORM	ANCE	(NCR)			, <u>-</u>
DATE	STEP	Description of NC	Corrective Action Section			0:	Verification		Approval	Approval
	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti	Section C	Chief Eng	QC Inspector
										-

Work Order ID 56742

March 5, 2010 11:23:47 AM



Page 3

Item ID:

D412-742-041

Accept

Setup Start

Stop



Revision ID:

Item Name:

Replacement Float Skidtube

Start Date:

05/03/2010

Start Qty: 1.00

Required Date: 17/03/2010 Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

QC:

Operation

Description

Date:_____

Tooling:

SPC (Y/N):

Set Up/

Run Hours

Date:

Date:

Draw

Rev.

Plan

Code

Run Start

Reject



Stop



Sequence ID/ **Work Center ID**

130

Packaging

Packaging

Packaging

Identify and pack for shipping as per PPP D412-742-

Date:_____

0.00

041 □Location: ____ □PPP Rev:

Draw

Number

Qty Qty

Accept

Reject Insp. Number Stamp

140

QC Quality Control QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

W/O:			W	ORK ORDER CHAN	NGES					
DATE	STEP	PRO	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
					·		<u></u>			
							•			
Part No		PAR #:	Fault Cate	egory:	NCR	: Yes I	No DQ	4 :	Date:	
		esolution:								
NCR:			WORK ORD	ER NON-CONFOR	MANCE	(NCR)			
DATE STEP		Description of NC	Corrective Action Section B Initial Action Description			Sign &	Verification		Approval	Approval
·		Section A	Chief Eng	Chief Eng	on	Date	Section	on C	Chief Eng	QC Inspector
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Picklist Print

March 5, 2010 11:23:51 AM

Work Order ID: 56742

Parent Item:

D412-742-041

Parent Item Name: Replacement Float Skidtube Comments:

IPP Rev A□05.10.13□New Issue□

IPP Rev B□06.02.13□ECN 773 dwg @ rev.D

IPP Rev:C 07-05-28 As per Rev F

IPP rev D 07.11.01 ecn 1053p

KJ/JLM□

EC

EC JLM Page 1

Start Date: 05/03/2010

Required Date: 17/03/2010

Start Qty: 1.00

Required Qty: 1.00

AN3C4A

Purchased

Purchased

No

No

110

Each

1,649.000 24.0000



BOLT

Warehouse		Loc Qty	Loc Code		
Location					
Main Warehouse					
ST		1649	M 11494	1 X 24	Hl 10/08/18
112314		13			
112720	'	12			
112724		3			
112829	J	1			·
112991		2 ·			
113121		64			
113226		344			
113644		110		-	
113749		100			
114103		500			
114108		500			
	110	Each	718.0000 12.0	0000	

AN3C6A

BOLT

Warehouse	Loc Oty	Loc Code		
Location				
Main Warehouse			0	10/02/18
ST	718		MX	10(08)10
(111982)	718			

w/o:		-	W	ORK ORDER CHANG	ES					
DATE	STEP	PRO	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								i		
			····				<u> </u>			
								:		
Part No	:	PAR #:	Fault Cat	legory:	_ NCR: Ye	es No	o DQ	\ :	Date:	
				QA: N/C Closed: Date:						
NCR:			WORK ORI	DER NON-CONFORMA	ANCE (N	CR)				- 64
DATE STEP		Description of NC	Corrective Action Section B				Verific	ation	Approval	Approval
DAIL	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		n & ite	Section C		Chief Eng	QC Inspector
										-
1	1				1					ŀ

Required Date: 17/03/2010

Required Qty: 1.00

31/80101 KR 8X

March 5, 2010 11:23:51 AM

Work Order ID: 56742

Parent Item:

D412-742-041

Parent Item Name:

Replacement Float Skidtube

Comments:

IPP Rev A□05.10.13□New Issue□

IPP Rev B□06.02.13□ECN 773 dwg @ rev.D

IPP Rev:C 07-05-28 As per Rev F IPP rev D 07.11.01 ecn 1053p

KJ/JLM□ EC JLM

EC

AN3C7A

Purchased

No

110

Each

485.0000 8.0000

Start Date: 05/03/2010

Start Qty: 1.00

BOLT

Warehouse	Loc Qty	Loc Code	
Location			
Main Warehouse			
ST	485		
105906	21		
107376	252		
(113149)	212		

AN960C10L

No Purchased

washer 4 NAS 1149 (0332 R

105906		21		
107376		252		
(113149)		212		
	110	Each	388.0000	44.0000



Warehouse	Loc Qty	Loc Code		
Location				
OFFSHORE				
FG	100	M115000	<u> </u>	10/08/18
103585	100	/ (110000	·	10)-110
Main Warehouse				
ST	288			
112116	128			
112612	160			

W/O:			V	VORK ORDER CHANG	iES					
DATE	STEP		CEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		•								·
			 			-		<u> </u>		
Part No	:	PAR #:	Fault Ca	tegory:	_ NCF	R: Yes	No DQ	4 :	_ Date: _	
	Resolution: Disposition:			ion:						
NCR:		V	WORK OR	DER NON-CONFORM	ANCE	(NCR)	<u></u>	-	
DATE	STEP	Description of NC	Corrective Action Section B				Verific	fication	Approval	Approval
DAIL	J.L.	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date		Section C	Chief Eng	QC Inspector
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Picklist Print

March 5, 2010 11:23:51 AM

Page 3

Required Date: 17/03/2010

Required Qty: 1.00

Work Order ID: 56742

Parent Item:

D412-742-041

Parent Item Name:

Replacement Float Skidtube

Comments:

IPP Rev A□05.10.13□New Issue□

IPP Rev B□06.02.13□ECN 773 dwg @ rev.D

IPP Rev:C 07-05-28 As per Rev F IPP rev D 07.11.01 ecn 1053p

KJ/JLM□

EC JLM

EC

AN960C416L

Purchased

No

110

Each

1,314.000 4.0000

Start Date: 05/03/2010

Start Qty: 1.00

WASHER

WHOTIER							·
		Warehouse	<u>Lo</u>	c Oty	Loc Code		
		Location					
		OFFSHORE					
		FG		44			
		104925		44			
		Main Warehouse					
		ST		1270			
		111916		2			
		112612		368			
\wedge	//	112794		500			
D3391-011		12828		400			<u>x4 %</u> 10/08/18
	A Manufactured No		110	Each	0.0000	1.0000	,
E NORINI 1909 JUNI INIO ENIO HINE HON HINE HINE HINE HINE HINE HINE HINE HIN	A Manufactured No well on Manufactured No	-0176171					XI B56727 JH 10/08/18
Fwd Tube Assembly	D) 1911	Bos					1. 500 16 . 21. 10108118
D3391-013	Manufactured No		110	Each	0.0000	1.0000	
							x 1 356731 Al 10/08/18
Mid Tube Assembly							XI 1000 121 N 10108119
D3391-015	Manufactured No		110	Each	0.0000	1.0000	
							X1 13 56735 JV 10108/18
Aft Tube Assembly							X1 12 16 +22 M 10 108/18

Dart Aerospac	e:e	Ltd
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W/O:			V	VORK ORDER CHANG	ES					
DATE	STEP	PRO	PROCEDURE CHANGE			Date Q	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
: 										
Part No	:	PAR #:	Fault Ca	tegory:	_ NCR: Yes	No DQA: _	Date: _			
	Resolution: Disposition:				QA: N/C Closed: Date:					
NCR:	Ì		WORK OR	DER NON-CONFORMA	ANCE (NCF	₹)				
DATE	STEP	Description of NC	NC Corrective Action Section			Verification	on Approval	Approval		
	0,2,	Section A	Initial Chief Eng	Action Description Chief Eng	Sign a	Section C		QC Inspector		
								-		
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Picklist Print

March 5, 2010 11:23:51 AM

Page 4

Required Date: 17/03/2010

Required Qty: 1.00

Work Order ID: 56742

Parent Item:

D412-742-041

Parent Item Name:

Replacement Float Skidtube

Comments:

IPP Rev A□05.10.13□New Issue□

IPP Rev B \square 06.02.13 \square ECN 773 dwg @ rev.D

IPP Rev:C 07-05-28 As per Rev F

IPP rev D 07.11.01 ecn 1053p

KJ/JLM□ EC

JLM

EC

D3564-1

Manufactured No

110

Each

18.0000 1.0000

Start Date: 05/03/2010

Start Qty: 1.00

Warehouse Location	Loc Oty	Loc Code	
OFFSHORE			
FG	2		
33798	2		
Main Warehouse			
ST	16		
47531	1		
50270	1		
(51676)	14		N 74 10108/18

									:
W/O:		All Annual Control	W	ORK ORDER CHANG	GES				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						·			
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQ	A:	Date: _	
	Res	olution:	Dispositio	n:	_ QA: N/C C	osed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORM	ANCE (NCF	R)	77,00		
DATE	STED	STEP Description of NC		Corrective Action Section B			cation Approval	Approval	
	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		on C	Chief Eng	QC Inspector
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Picklist Print

March 5, 2010 11:23:51 AM

Page 5

Required Date: 17/03/2010

Required Qty: 1.00

Work Order ID: 56742

Parent Item:

D412-742-041

Parent Item Name:

Replacement Float Skidtube

Comments:

IPP Rev A□05.10.13□New Issue□

IPP Rev B□06.02.13□ECN 773 dwg @ rev.D

IPP Rev:C 07-05-28 As per Rev F

KJ/JLM□

EC

JLM EC

IPP rev D 07.11.01 ecn 1053p

Manufactured No

110

Each

19.0000 1.0000

Start Date: 05/03/2010

Start Qty: 1.00

Wearshoe

D3564-3

Warehouse	Loc Oty	Loc Code	
Location			
OFFSHORE			
FG	2		
33764	2		
Main Warehouse			
FP	5		
50113	5		
Main Warehouse			
FP19	11		
(55489)	11		81/80/01 PK /V
Main Warehouse			1 70 81 18
ST	1		
46445	1		

Dart	Aeros	pace	Ltd
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W/O:		444	WC	RK ORDER CHANG	ES				ı	
DATE	STEP	PRO	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DOA	.•	Date:		
Part No: PAR #: Resolution:				Disposition: Q						
NCR:			WORK ORDI	ER NON-CONFORMA	ANCE (NCR	3)				
DATE	STEP	Description of NC Section A	Initial Action Description Chief Eng Chief Eng		ion B Sign & Date	Verification Section C		Approval Chief Eng	Approval QC Inspector	
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Picklist Print

March 5, 2010 11:23:51 AM

Page 6

Work Order ID: 56742

Parent Item:

D412-742-041

Parent Item Name:

Replacement Float Skidtube

Comments:

IPP Rev A□05.10.13□New Issue□

IPP Rev B□06.02.13□ECN 773 dwg @ rev.D

IPP Rev:C 07-05-28 As per Rev F

IPP rev D 07.11.01 ecn 1053p

KJ/JLM□

EC JLM

EC

Start Date: 05/03/2010

Required Date: 17/03/2010

Required Oty: 1.00

D3564-5

Manufactured

No

110

Each

36.0000 1.0000



Start Oty: 1.00

Wearshoe

Warehouse Location	Loc Oty	Loc Code	
Location			
OFFSHORE		B59157	11
FG	2	D5 (1)4	XI M 10/08/15
34806	2		
Main Warehouse			
FP19	32		
51925	1		
54772	6		
55024	12		
55333	13		
Main Warehouse			
ST	2		
45824	1		
47433	1		

Dart Aeros	space Ltd
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	1								1		
W/O:			W	ORK ORDER CHANG	ES	,					
DATE	STEP	PRO	PROCEDURE CHANGE					Approval Chief Eng / Prod Mgr	Approval QC Inspector		
							<u> </u>				
Part No	:	PAR #:	Fault Cate	egory:	NCR: Yes	No DQ	A:	_ Date: _			
	Re	esolution:	Disposition	on:	QA: N/C Closed: Date:						
NCR:	:		WORK ORD	ER NON-CONFORMA	NCE (NCF	₹)					
DATE	STEP	Description of NC		Corrective Action Section		Verificat		Approval	Approval		
	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date		ion C	Chief Eng	QC Inspector		
									-		
	:										

Required Date: 17/03/2010

Required Qty: 1.00

March 5, 2010 11:23:51 AM

Work Order ID: 56742

Parent Item:

D412-742-041

Parent Item Name:

Replacement Float Skidtube

Comments:

IPP Rev A□05.10.13□New Issue□

IPP Rev B□06.02.13□ECN 773 dwg @ rev.D

IPP Rev:C 07-05-28 As per Rev F

IPP rev D 07.11.01 ecn 1053p

KJ/JLM□ EC

JLM

EC

D3566-1

Manufactured

110

Each

23.0000 2.0000

Start Date: 05/03/2010

Start Qty: 1.00

*	H
Gasket	

Warehouse	Loc Oty	Loc Code			
Location					
Main Warehouse	•	1360857		1	1 , -
FP	18	_	XZ_	1 بالا	10/08/18
52512	3				
54480	1				
55011	1				
55320	13				
Main Warehouse					
ST	5				
46349	1				
51218	1				
51259	3				

W/O:			W	ORK ORDER CHANG	GES		1					
DATE	STEP	PRO	CEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
, <u> </u>							J					
									. •			
									•			
Part No		PAR #:										
	R		Disposition: QA: N/C Closed:									
NCR:		V	VORK ORE	DER NON-CONFORM	ANCE	(NCR)					
DATE	STEP	Description of NC	Initial		tion B	Cian 9	Verific		Approval	Approval		
		Section A	Chief Eng	Action Description Chief Eng		Sign & Section C		on C	Chief Eng	QC Inspector		
										-		
								1				

March 5, 2010 11:23:51 AM

Work	Order	ID:

56742

Parent Item:

D412-742-041

Parent Item Name:

Replacement Float Skidtube

Comments:

IPP Rev A□05.10.13□New Issue□

IPP Rev B□06.02.13□ECN 773 dwg @ rev.D

IPP Rev:C 07-05-28 As per Rev F IPP rev D 07.11.01 ecn 1053p

Manufactured

KJ/JLM 🗆

EC JLM EC

Start Date: 05/03/2010

Required Date: 17/03/2010

Start Otv: 1.00

Required Qty: 1.00

D3566-5

Manufactured

No

No

110

Each

26.0000 1.0000

Gasket

Warehouse Location	Loc Q	<u>oty</u>	Loc Code		
Location					
Main Warehouse			13591	58	
FP19		22	15 0	, ,	31/30/01 KU 1X
55026		10			
55335		12			
Main Warehouse					
ST		4			
36113		1			
46186		1			
47318		1			
51260		1			-
	110	Each	37.0000	2.0000	

D3591-1

Bushing

Warehouse Loc Qty Location Main Warehouse ST 37 46105 29

47121

1357350

Loc Code

XI M 10/08/18

W/O:			W	ORK ORDER CHAN	GES		***					
DATE	STEP	PRO	OCEDURE CHA			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
Part No		PAR #:										
	R		Disposition: QA: N/C Clos									
NCR:			WORK ORD	ER NON-CONFORM	MANCE	(NCR)					
DATE	STEP	Description of NC			ection B		Verification Approva		Approval	Approval		
DAIL	JILI	Section A	Initial Chief Eng	Action Description Chief Eng) 	Sign & Date		Section C		QC Inspector		
		·										

March 5, 2010 11:23:51 AM

Work Order ID: 56742

Parent Item:

D412-742-041

Parent Item Name:

Replacement Float Skidtube

Comments:

IPP Rev A□05.10.13□New Issue□

IPP Rev B□06.02.13□ECN 773 dwg @ rev.D IPP Rev:C 07-05-28 As per Rev F

IPP rev D 07.11.01 ecn 1053p



KJ/JLM□ EC

JLM EC

Start Date: 05/03/2010

Required Date: 17/03/2010

Start Qty: 1.00

Required Qty: 1.00

D3672-3

Manufactured

No

110

Each

4

2

524.0000 4.0000



Phenolic Washer

Warehouse	<u>L</u>	oc Oty	Loc Code			
Location						
Main Warehouse						
ST117		24	1357	704	LX LU	10108/18
51596		24				
Main Warehouse						
ST77		500				
55560		500				
	110	Each	22.0000	4.0000	· 	

MS27039C4-12

Purchased

No



SCREW

Warehouse Loc Oty **Location** Main Warehouse ST22 12726 2296 5558 16

Loc Code

114221

HI 10/08/15

March 5, 2010 11:23:51 AM

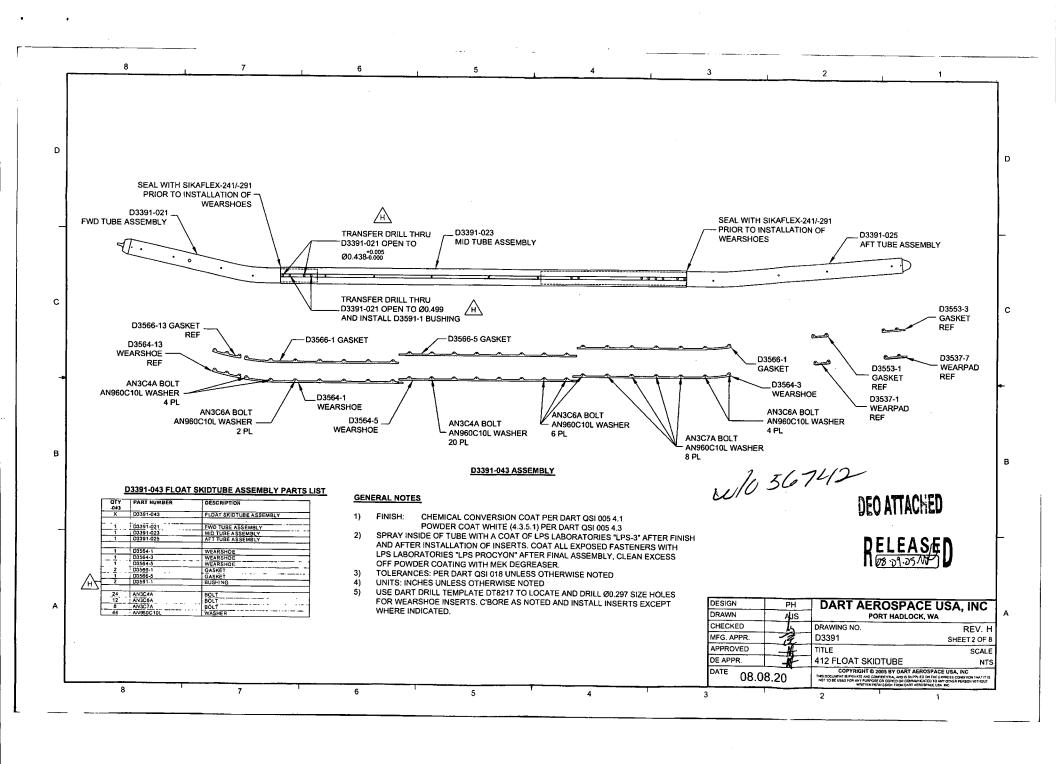
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W/O:			W	ORK ORDER CHAN	IGES							
DATE	STEP	PR	PROCEDURE CHANGE By					Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
								·				
Part No	:	PAR #:	Fault Cate	egory:	NC	R: Yes	No DQA:		_ Date: _	·		
	R	esolution:	Disposition	Disposition: QA: N/C Clos					losed: Date:			
NCR:			WORK ORD	ER NON-CONFORI	MANCE	(NCR)		- 1/4 - 14 - 44 - 44 - 44 - 44 - 44 - 44			
DATE	STEP	Description of NC			ection B		Verification Approve		Approval	al Approval		
	J	Section A	Initial Chief Eng	Action Description Chief Eng	n 	Sign & Section C		ı C	Chief Eng	QC Inspector		
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RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO. 3-05 SEAL WITH SIKAELEY-241/-291 PRIOR TO INSTALLATION OF WEARSHOES D3391-011 MS27039C4-12 SCREW SEAL WITH SIKAFLEX-241/-291 FWD TUBE ASSEMBLY D3672-3 WASHER PRIOR TO INSTALLATION OF D3391-013 AN960C416L WASHER D3391-015 TRANSFER DRILL THRU WEARSHOES MID TUBE ASSEMBLY AFT TUBE ASSEMBLY D3391-011 OPEN TO Ø10 438-0 000 0 0 0 0 TRANSFER DRILL THRU D3553-3 D3391-011 OPEN TO Ø0,499 GASKET AND INSTALL D3591-1 BUSHING D3566-13 GASKET RFF D3537-7 D3566-5 GASKET D3566-1 GASKET D3564-13 WEARPAD WEARSHOE REF D3566-1 REF GASKET D3553-1 GASKET D3564-3 AN3C4A BOLT (1) AN960C10L WASHER (1) WEARSHOE D3564-1 WEARSHOE WEARPAD AN3C6A BOLT AN3C6A BOLT (1) AN3C6A BOLT AN3C4A BOLT (1) D3564-5 AN960C10L WASHER (1) AN960C10L WASHER AN960C10L WASHER WEARSHOE LAN960C10L WASHER (1) 2 PI 6 PI AN3C7A BOLT -AN960C10L WASHER D3391-041 ASSEMBLY DRAWING UPDATED TO CURRENT STANDARDS SHT 1 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0,499 DIM AND D3591-1 BUSHING. 08.08.20 SHT 2 PL ADDED D3591-1 BUSHING, ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DSI 9364 & NCR 08-074) REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING 07 07 31 DC FLOAT BAGS, DWG REORGANIZED FOR CLARITY ADD SS WEARSHOE GASKET D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST PH 07.01.18 REMOVE FWD SADDLE HOLE -011/-021 DESCRIPTION **GENERAL NOTES** CHANGE TOLERANCE, EASE MANUFACTURE PH 06.04.25 UPDATE TOLERANCE, CHANGE HOLE SIZE PH 06.01.23 FWD TUBE ASSEMBLY FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 D3391-01 LENGTHEN AFT EXTENSION PH 05.09.27 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3 SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH DRAWING UPDATES В PH 05.06.10 AND AETER INSTALLATION OF INSERTS, COAT ALL EXPOSED FASTENERS WITH A NEW ISSUE 05.02.07 PH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS D3564-5 REV. DESCRIPTION DATE BY OFF POWDER COATING WITH MEK DEGREASER. DESIGN DART AEROSPACE USA, INC PH TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED DRAWN AJS PORT HADLOCK, WA UNITS: INCHES UNLESS OTHERWISE NOTED CHECKED USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES DRAWING NO. REV. H FOR WEARSHOE INSERTS, C'BORE AS NOTED AND INSTALL INSERTS EXCEPT MFG. APPR. D3391 SHEET 1 OF 8 WHERE INDICATED. APPROVED TITLE SCALE DE APPR 412 FLOAT SKIDTUBE THIS DOCUMENT OF PRINCE OF COMPANIES AND COMPANIES OF COMPANIES AND COMP DATE 08.08.20

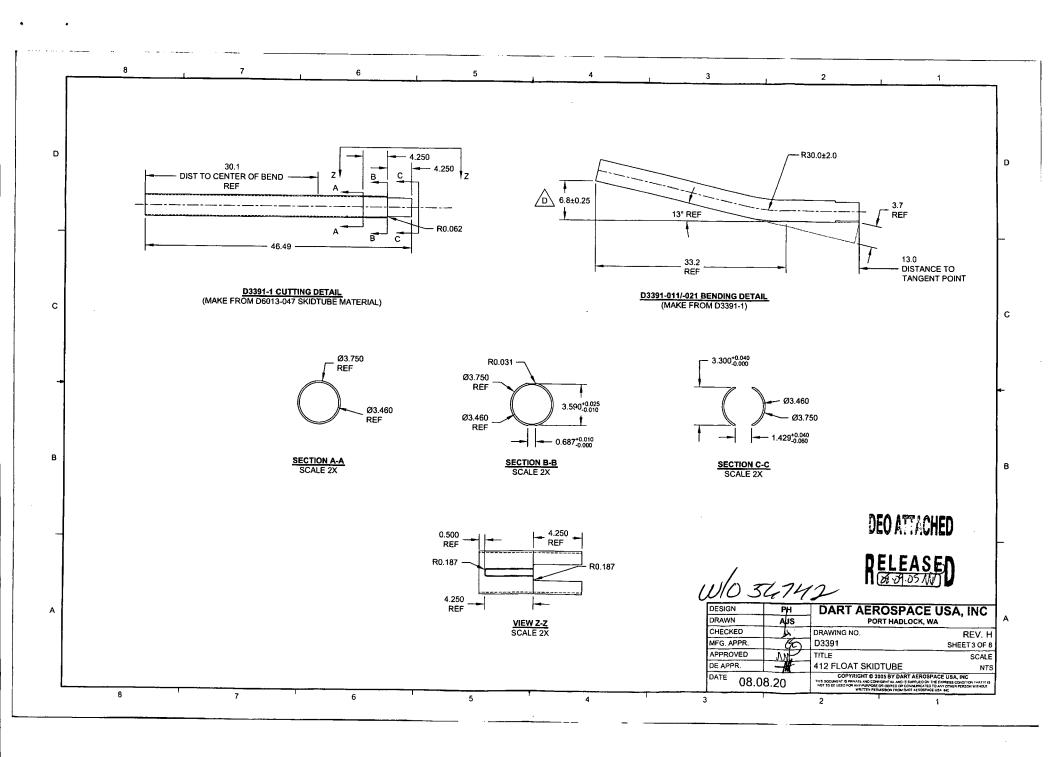
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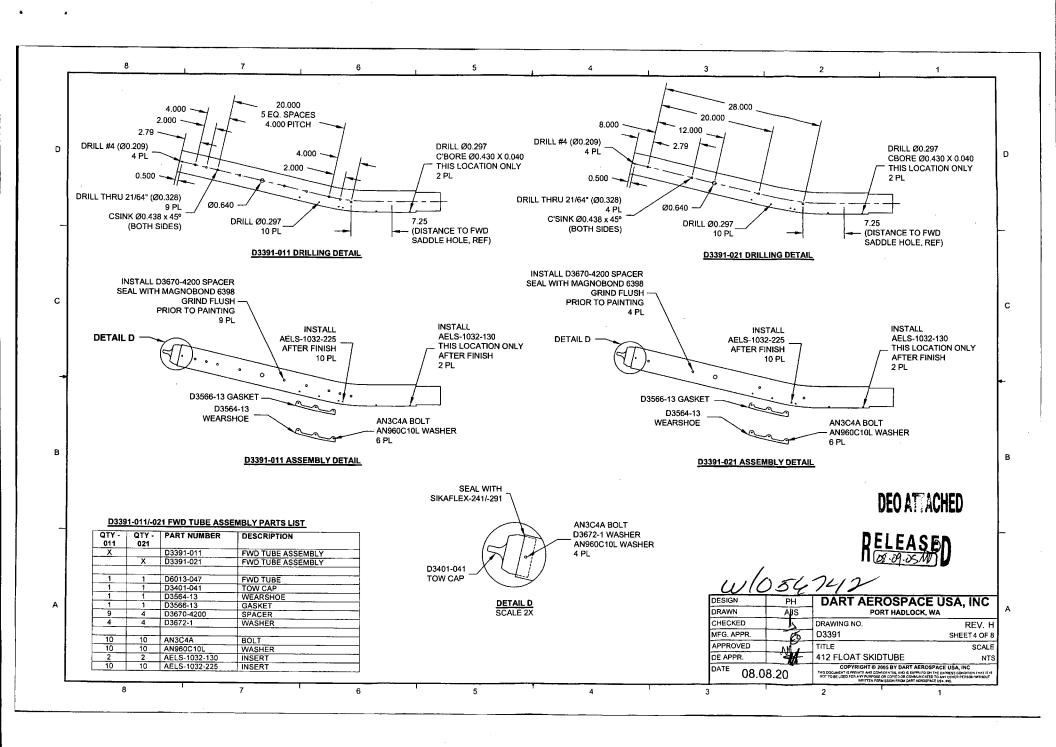
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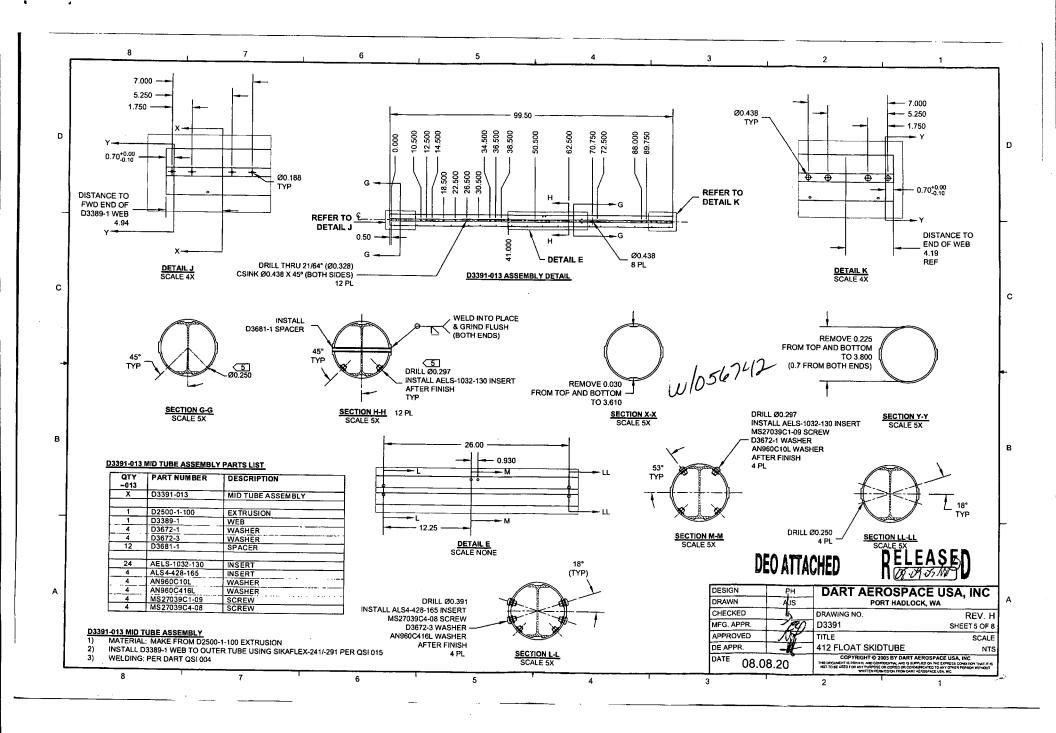
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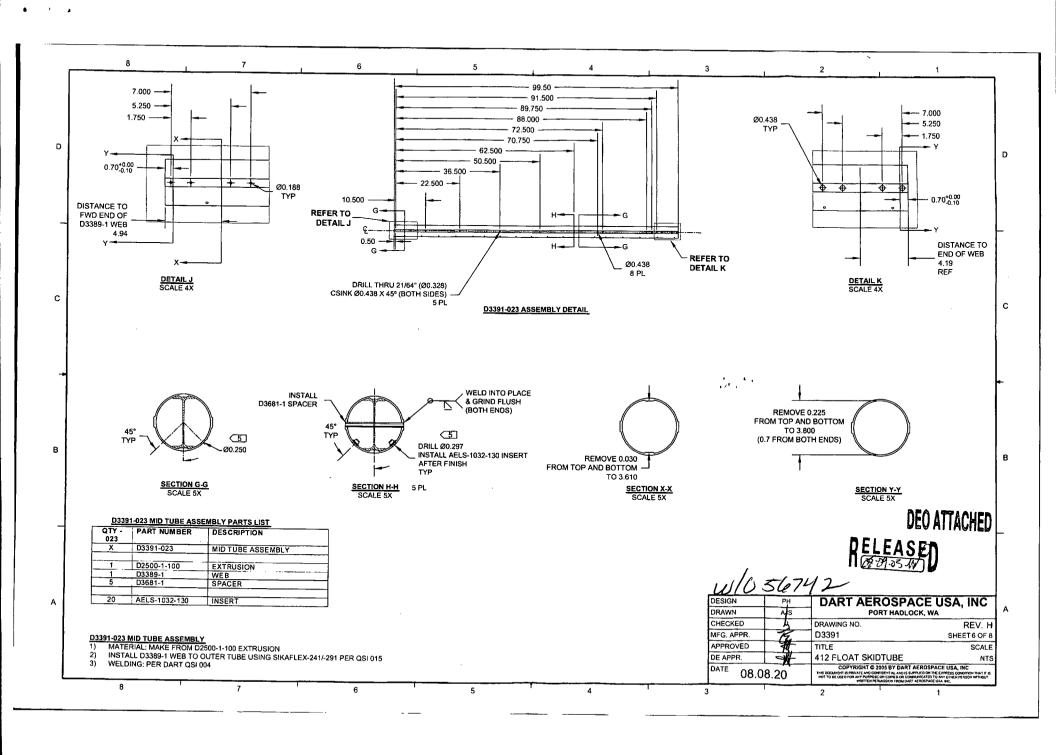
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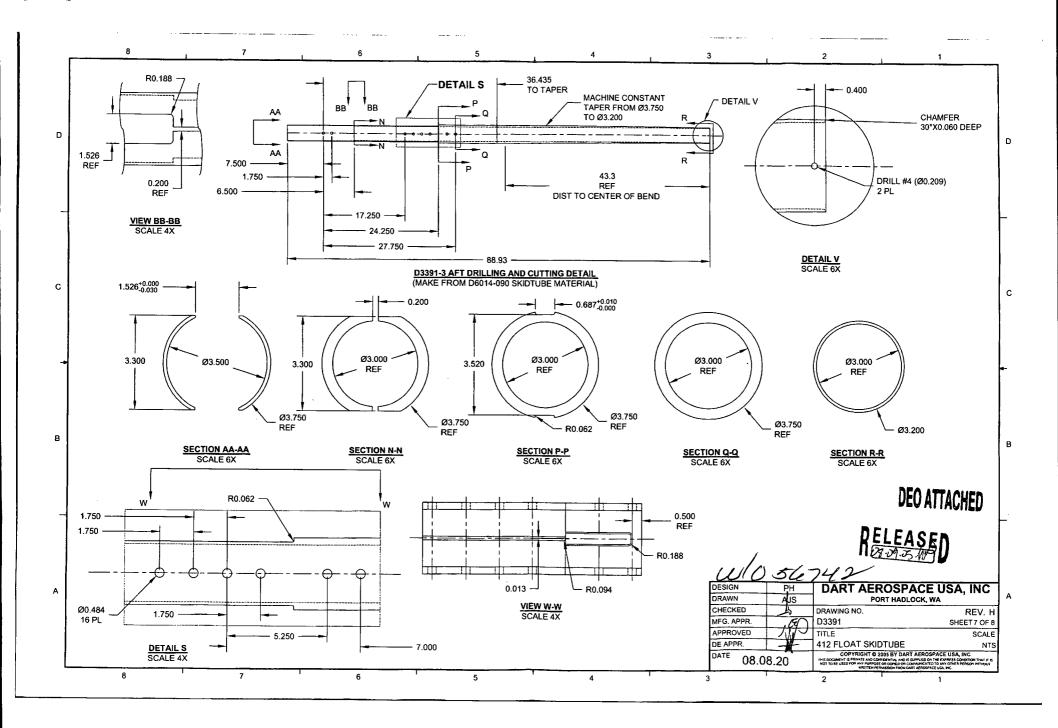


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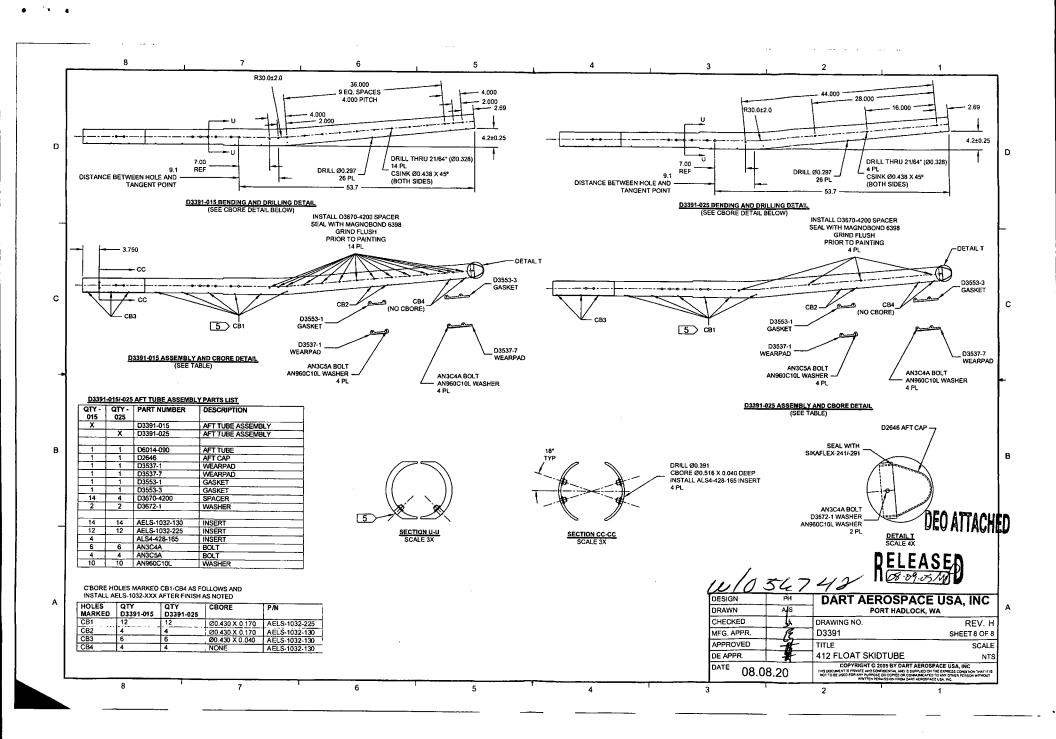
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PURPOSE:

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF D3391-041/-043 SKIDTUBES.

CHANGE:

AMEND NOTE 2 OF D3391-041/-043 SKIDTUBE ASSEMBLIES (ZN A6-1, A6-2) AS FOLLOWS:

2) SPRAY INSIDE OF TUBE WITH A COAT-OF-LPS LABORATORIES "LPS-3" AFTER FINISH-AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

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